

Date: Wednesday, 10/10/2007 11:03:45 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 35083 -2
Estimate Number : 11234
P.O. Number :
This Issue : 10/10/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : THERMOFORMING
Previous Run : 33898
Written By :
Checked & Approved By :
Comment : Est Rev: A 04.07.01 New issue KJ/JLM
Est Rev B 07.08.07 Thermoform in house DL

Drawing Name : FLOOR PROTECTOR FWD RH
Part Number : D32812
Drawing Number : D3281 REV B
Project Number : N/A
Drawing Revision : B1
Material :
Due Date : 11/2/2007
Qty: 20 Um: Each

UNDER REVIEW
OR TO PRODUCE
LE 07.10.12
LE 08.01.07

POSITIVE
RECALL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 F6002 701 lexan black



Comment: Qty.: 4.3600 sf(s)/Unit Total : 87.2000 sf(s)
lexan black .125"

Material Batch # M106957

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

BB 08/01/30

3.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 008

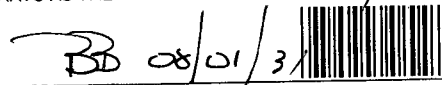
Dwg. Rev. _____

Folio Rev. _____

BB 08/01/31

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Date: Wednesday, 10/10/2007 11:00:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR FWD RH

Job Number: 35083

Part Number: D32812

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB
BB

08/02/01
08/02/02

FAI
X
X
X

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

X10
BB 08/02/02

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/04 (X10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

264

8/2/5

SC

10X

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/07

Job Completion



POSITIVE RECALL

EFFECTIVE 10/10/07

AUTH [Signature]

RELEASED [Signature]

DATE 08-01-04

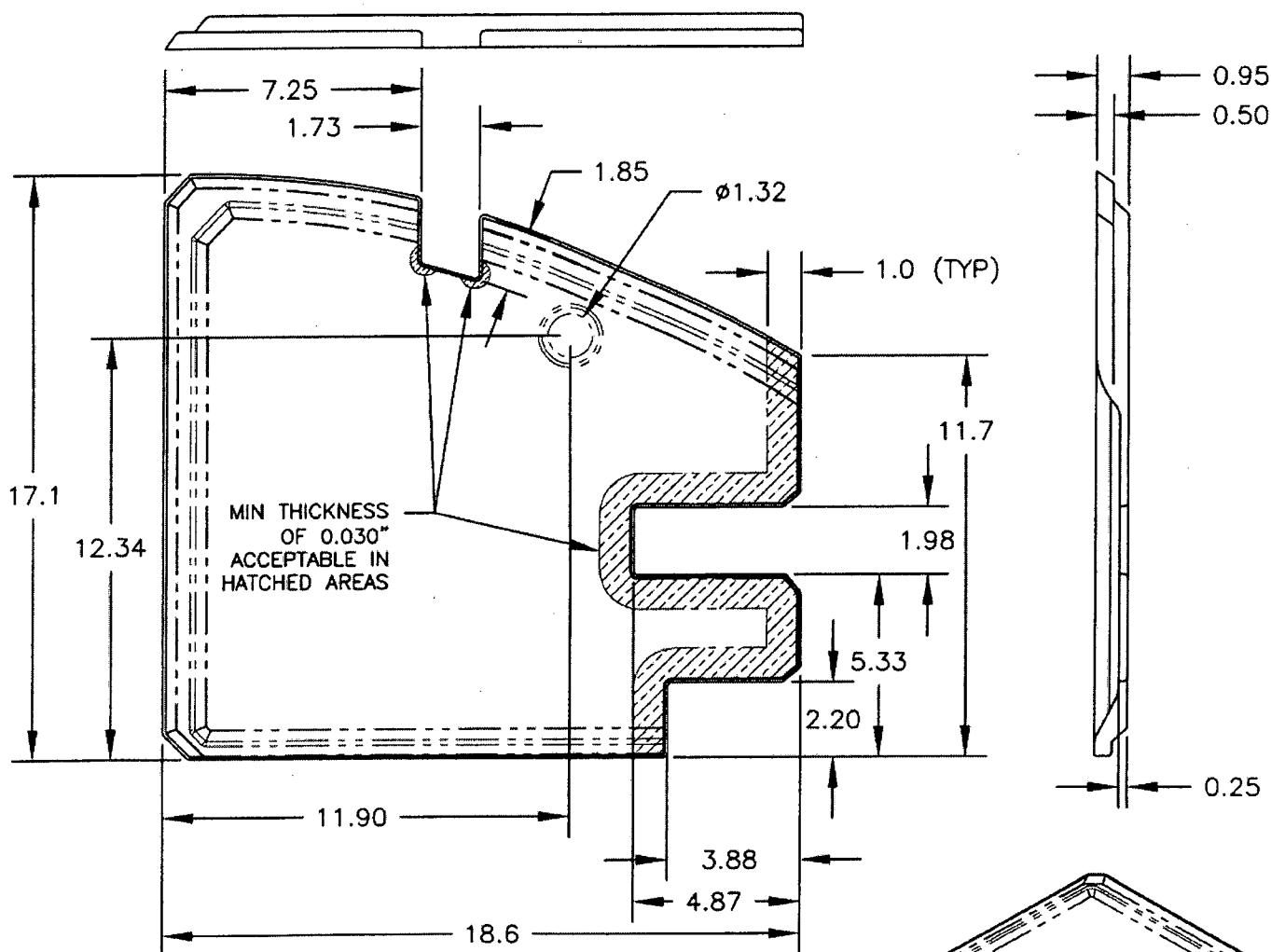
2008/2/06

[Signature]

(10)



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3281 | REV. B SHEET 1 OF 3 |
| DATE 05.11.25 | | TITLE FLOOR PROTECTOR | SCALE 1:5 |
| A | 04.05.03 | NEW ISSUE | |
| B | 05.11.25 | NOW LEXAN; DIMS AS MANUFACTURED | |



RELEASED
05.12.01

UNDER REVIEW

07.10.05 LE

OK TO MANUFACTURE
AND SHIP

D3281-1 FLOOR PROTECTOR. FWD LH

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

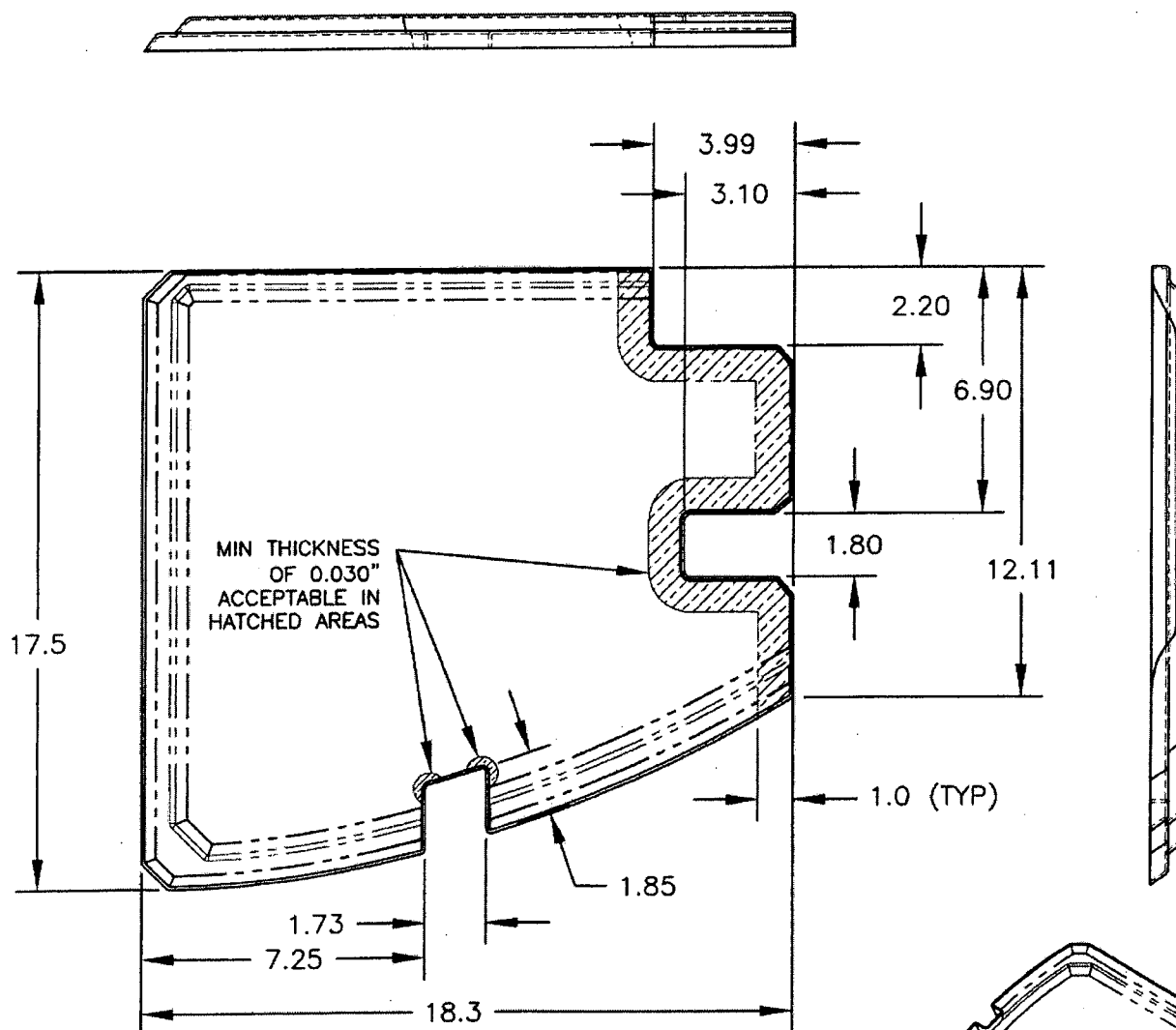
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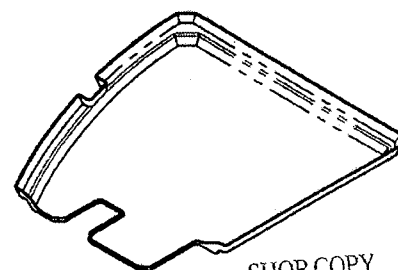
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3281 | REV. B SHEET 2 OF 3 |
| DATE 05.11.25 | | TITLE FLOOR PROTECTOR | SCALE 1:5 |



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07.10.05 LE
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AND SHIP



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D3281-2 FLOOR PROTECTOR, FWD RH

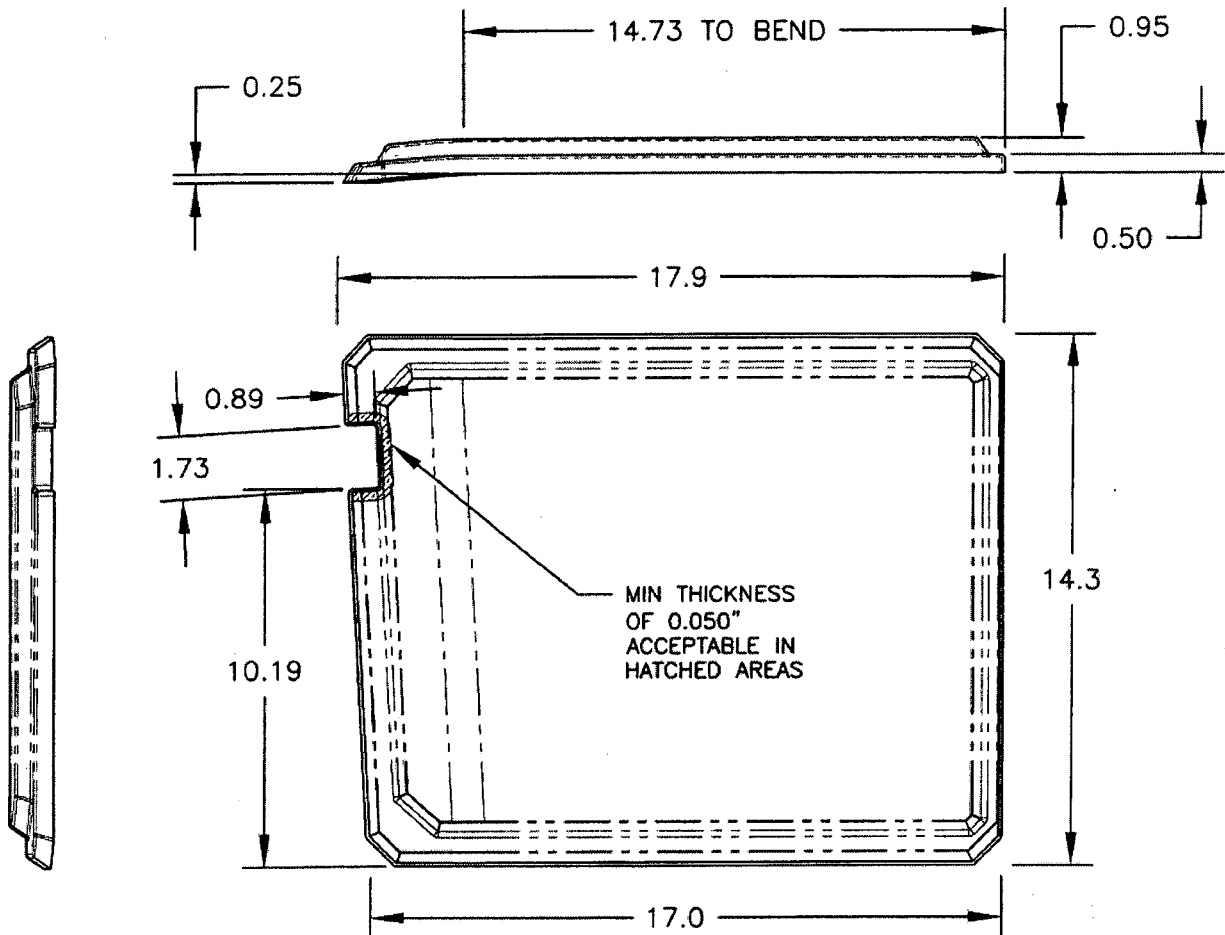
- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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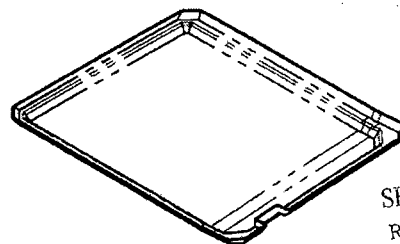
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| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3281 | REV. B SHEET 3 OF 3 |
| DATE 05.11.25 | | TITLE FLOOR PROTECTOR | SCALE 1:5 |



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05.12.01. *[Signature]*

UNDER REVIEW

07.10.05 LG
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AND SHIP



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WORK ORDER
NO. _____

D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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| | | |
|--|--|----------------------|
| DART AEROSPACE LTD | | Work Order: 35083-2 |
| Description: R 44 FLOOR PROTECTOR TWO RH | | Part Number: D3281-2 |
| Inspection Dwg: D3281 Rev: B. | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than 3/16 " Go/No Go | BB | | | |
| Shape Definition | BB | | | |
| Texture Retention | BB | | | |
| Material imperfections such as bumps, cracks, voids, scratching | BB | | | |

Measured by: BB Date: 08/02/01

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 18.3 " | ± .100" | 18.27 | BB | | | |
| 17.5 " | ± .100" | 17.35 | BB | | | |
| 12.11 " | ± .100" | 12.1 | BB | | | |
| .95 " | ± .030" | .981 | BB | | | |
| .25 " | ± .030" | .261 | BB | | | |
| 1.80 " | ± .100 | 1.80 | BB | | | |
| | | | | | | |
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| | | | | | | |

Measured by: BB Date: 08.02.01

Audited by: Date: 08.02.01

Prototype Approval: Date: 08.02.01

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/DL | |